

REFLOW RECOMMENDATION

RECOMMENDED TEMP PROFILE

Profile Feature	Pb Free Assy
Average Ramp-up Rate ($T_{s_{max}}$ to T_p)	3 °C/second max
<p style="text-align: center;">PREHEAT</p> <ul style="list-style-type: none"> - Temperature Min ($T_{s_{min}}$) - Temperature Max ($T_{s_{max}}$) - Time ($t_{s_{min}}$ to $t_{s_{max}}$) 	<p style="text-align: center;">150 °C 200 °C 60-180 seconds</p>
<p style="text-align: center;">Time Maintained Above:</p> <ul style="list-style-type: none"> -Temperature (T_L) -Time (t_L) 	<p style="text-align: center;">217 °C 60-150 seconds</p>
Peak/Classification Temp (T_p)	260 deg C Max
Time within 5 °C of Actual Peak Temperature (t_p)	20- 40 seconds
Ramp Down Rate	6 °C/second max
Time 25 °C to Peak Temperature	8 minutes max
4/3/2018	

RECOMMENDED OVEN PROFILE (Pb FREE)

